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D3407-1

Job Sheet 201238



Part No: D3407-1

Job Qty: 40 pcs

Part Name: Stem



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Doosan - 1	40 pcs		10/21/19	1.00	16.06	Doosan - 1	19/10/15
110	QC 2	40 pcs		10/21/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							Plex 9/27/19 12:50 PM Dart.lajeunesse.marie	

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120 QC 8	40 pcs	10/21/19	0.00	0.00	QC 2 - 65	19/10/15
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	19/10/17
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	40 pcs	10/21/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	10/21/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - 1-Turn as per Folio FA596 Rev: AA & Dwg D3407 Rev: G Mill slot width at max tolerance .260" 2-Deburr
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: 11400) LOCATION: WA001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	18.3600 ft (.459 ea)	100-Doosan - 1	S159389 S151402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-R0.750	18	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches ± 0.010	0.073 0.053		
2	Tow Ring	0.26520Inches + 0.00160 - 0.00170	0.26680 0.26350	1/4-28 UNF	
3	Tow Ring	0.24575Inches ± 0.00325	0.24900 0.24250	Major ♦	
4	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
5	Tow Ring	0.363Inches ± 0.010	0.373 0.353		
6	Tow Ring	0.750Inches ± 0.010	0.760 0.740		
7	Tow Ring	0.100Inches ± 0.010	0.110 0.090	Radius	
8	Tow Ring	0.470Inches ± 0.010	0.480 0.460		
9	Tow Ring	0.500Inches ± 0.010	0.510 0.490		
10	Tow Ring	3.25Inches ± 0.01	3.26 3.24		
11	Tow Ring	4.250Inches + 0.000 - 0.010	4.250 4.240		
12	Tow Ring	5.270Inches ± 0.010	5.280 5.260		
13	Tow Ring	0.150Inches ± 0.010	0.160 0.140		
14	Tow Ring	0.550Inches ± 0.010	0.560 0.540		
15	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
16	Tow Ring	0.250Inches + 0.010 - 0.000	0.260 0.250		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework Scrap Use-as-is		Cross tube Small Fab Finishing	
		Skid-tube Machining Large Fab		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
		Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY			
		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			
		Other/Details:			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			